

Thursday, December 22, 2016 10:52:13 AM

Page 1

Approvals: **Process Plan:** mf **Date:** 16-12-27 **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5021	B								
110		0.00							
110									
Purchasing									
Purchasing		0.11							
	Memo								
	Issue P/O: _____								
	Manufacture as per Dwg								
	Possible supplier: ACP COMPOSITES								
	C OF C note is required.								
120		0.00							
120									
Packaging									
Packaging		0.01							
	Memo								
	C OF C note is required.								
130		0.00							
130									
QC									
Quality Control		0.00							

Work Order ID 154853***154853***

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Item ID: D5021-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Foam, Center Panel, Fwd
Start Date: 12/22/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/13/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <u>D/0 157417 x1</u> <u>w/0 156473 x1</u>	0.00 0.01	<u>51475A</u> <u>479A</u>			<u>4</u>	<u>MAR 06 2017</u>	<u>DAS 6 9-89</u>	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07						<u>DAS 21 9-89</u>	<u>MAR 07 2017</u>

Picklist Print

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Page 1

Work Order ID: 154853

154853

Parent Item: D5021-1

D5021-1

Parent Item Name: Foam, Center Panel, Fwd

Start Date: 12/22/2016

Required Date: 1/13/2017

Start Qty: 4.00

Required Qty: 4.00

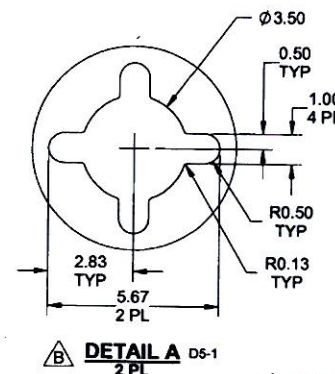
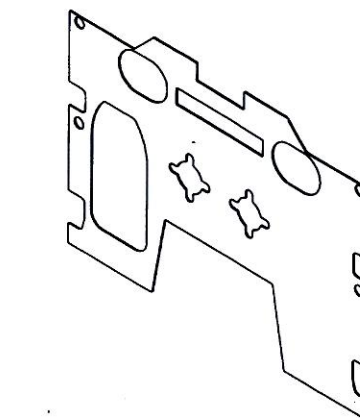
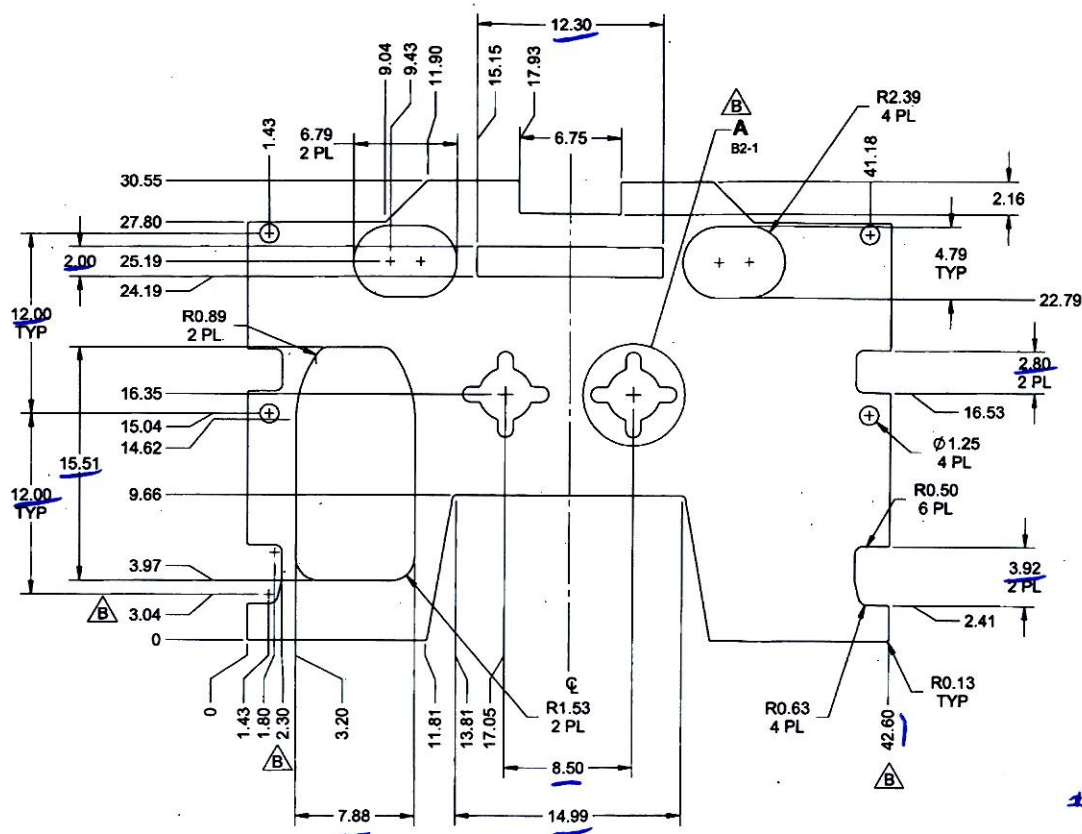
Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.04.09 NOW OUTSOURCE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5021-1P		Purchased	No				Each	0.0000		4			
D5021-1P									**				

Foam, Center Panel, Fwd

D5033-1

42 17/02/27
9.25 of each
total - 37.03



D5021-1 FOAM, CENTER PANEL, FWD

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

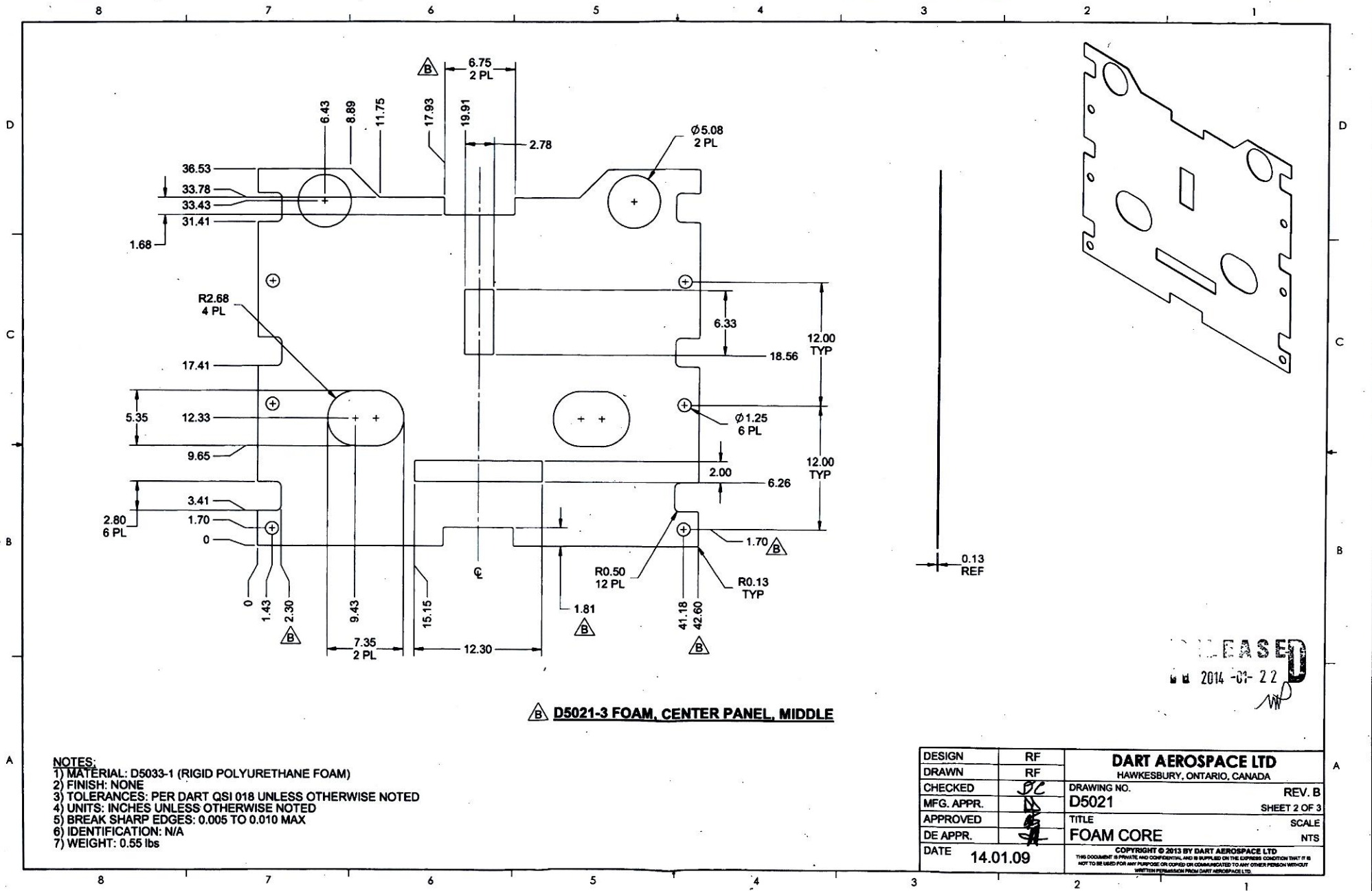
154853
MF. 10-12-22

RELEASED
2014-07-22

B	ADDED DETAIL A (ZN B2-1, D5-1) & 1.81 (ZN B5-2, B5-3), 6.75 (ZN D6-2, B6-3); 3.04 WAS 2.93 (ZN B7-1); 2.30 WAS 1.64 & 1.51 (ZN B7-1, B7-2, B7-3); 1.70 WAS 1.83 (ZN B4-2); 9.90 WAS 9.78 (ZN B4-3); SOME DIMENSIONS SHIFTED DUE TO WIDTH CHANGE		RF	14.01.09
A	NEW ISSUE		RF	13.12.09
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	DC	DRAWING NO.	REV. B	
MFG. APPR.	DS	D5021	SHEET 1 OF 3	
APPROVED	SA	TITLE	SCALE	
DE APPR.	SA	FOAM CORE	NTS	
DATE	14.01.09			

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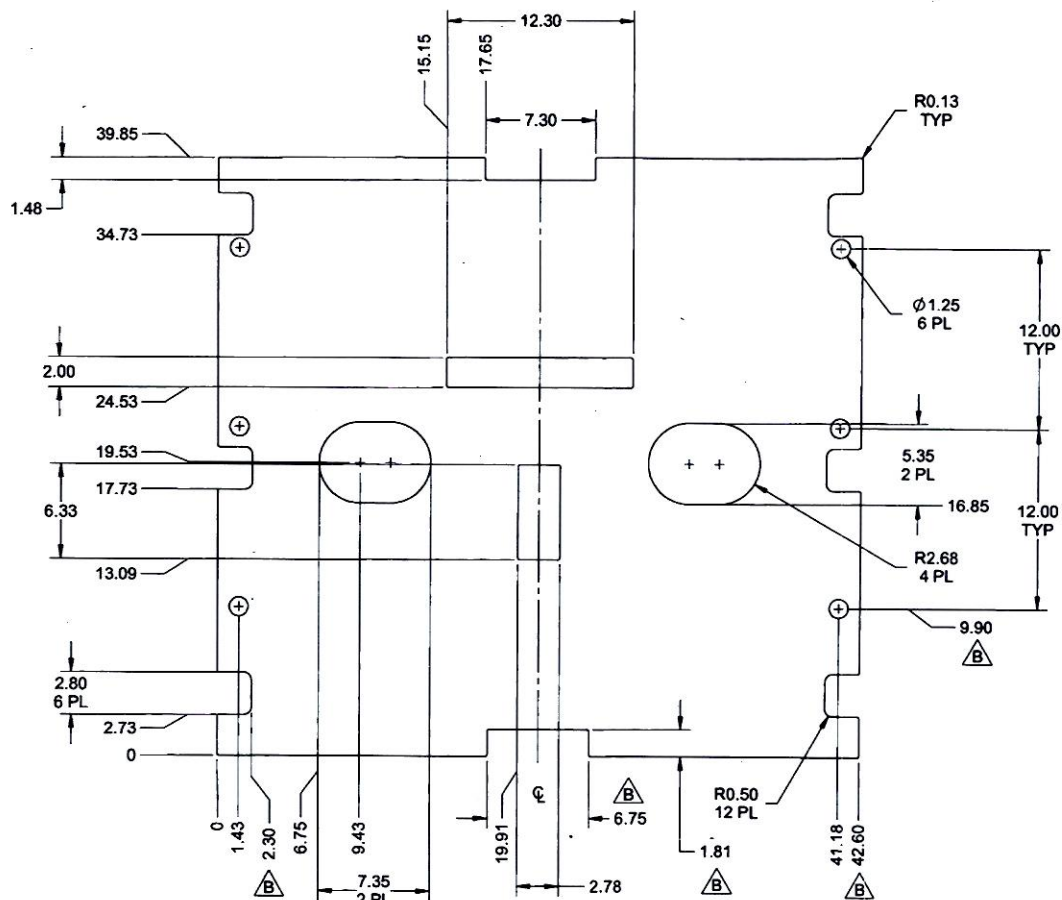
8 7 6 5 4 3 2 1

D

C

B

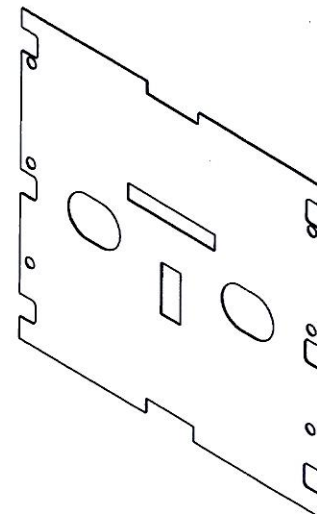
A



D5021-5 FOAM, CENTER PANEL, AFT

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs



RELEASED
2014-01-22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	PC	D5021	SHEET 3 OF 3
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	FOAM CORE	NTS
DATE	14.01.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 154853
Description: Foam center Fwd		Part Number: 5021-1
Inspection Dwg: 5021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.25	-0.001 +0.012	Ø 1.249	1		V-D-02	
Ø 3.50	-0.001 +0.012	Ø 3.50	1		Tape	
1.00	+/- .030	1.00	1			
5.67	+/- .030	5.67	1			
2.00	+/- .030	2.00	1			
12.00	+/- .030	12.00	1			
12.30	+/- .030	12.30	1			
7.88	+/- .030	7.88	1			
14.99	+/- .030	14.99	1			
8.50	+/- .030	8.50	1			
2.80	+/- .030	2.80	1			
3.92	+/- .030	3.92	1			
30.55	+/- .030	30.55	1			
42.60	+/- .030	42.60	1			
15.51	+/- .030	15.51	1			

Measured by: DC	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 17/02/27	Date: MAR 06 2017	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	